120

QC

\*120\*

Quality Control

QC8- Inspect parts - second check

Memo

		DQA:	Date:	•
NCR: Yes / No	WORK ORDER NON-CONFORMANCE / UPDATE	-		

									QA Closed:	Date:	
Work Orde	r:	-			DISPOSITION			AGAINST DE	PARTMENT	PROCESS	
Part N					Rework Scrap Use-as-is Work Order Update		Skid-tube  Machining  noforming  Large Fab	Crosstube Small Fab Finishing Composite		Water Jet d. Eng. Coor. re/Packaging Supplier	Engineering Quality Other
Root		T		Descri	ption of work order update	Initial	Initial Action		Sign &		
Cause	Date	Step	Qty	,	or Non-conformance	Chief Eng	Descr	iption	Date	Verification	QC Inspector
Doc/Data											
Equip/Tooling											
Operator		-									
Material [											
Setup											
Other											
Process	``	}									
Supplier											
Training											
Unapproved	· ]			.,							
						AULT CATE	GORY				
Landin F	ng Gear			_	General	<b>—</b> .			1		1
	Bending	•		_	Bend	Grain		<b>—</b>	Ovalized		Pressure/Forced
	Centre N	ot Concer	ntric to	o/s	BOM/Route	Hardwa		<del>}</del>	Over/Under		Temperature/Cure
-	Cracks				Broken/Damaged	<b>⊢</b> ⊣ '	ion Incomplete	<u> </u>	Part Incorred	· —	Weld
ŀ	Crushed/Crimped. Burrs					· .	tions Incomplete/L	<u> </u>	Part Lost/Mi	ssing	Wrong Stock Pulled
-	Contamination				<del>  </del>	enance	<del></del>	Part Moved			
-	Heat Treat Countersink			Mislabe			Positioned V		1		
	Inspection Strip in Tube Cut Too Short			4	Misrea	d		Power Loss/	Surge	Other	
	Ripples in Bend Drill Holes			Offset							
-	<b>  </b>			Drawing	Out of Calibration						
ļ				Finish	Out of Sequence						
]	Wave/Twist in Tube				Folio	Outside	e Dimensions				

H:/FORMS/Quality Assurance\approved QA/NCRWO Rev G

July-19-12 11:30:27 AM

Item ID:	D3245-7
Revision ID:	
Item Name	Gasket

**Required Date:** 02/08/2012

Accept

\*N900040100\*

Setup Start

**Start Date:** 

19/07/2012

**Start Qty: 20.00** Req'd Qty: 20.00

\*20\*

**Cust Item ID:** 

**Customer:** 

Reference:

			·					_	. 64-	1	
Approvals:	Process Plan:	** ** ** **	Date:	Tooling:	Da	ate:		R			R1*
	QC:		Date:	SPC (Y/N):	Date:			Stop *NR2*			R2*
Sequence ID/ Work Center II	-	eration cription		Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130	Iden	tify as per dwg & S	tock Location:	0.00							
*130* Packaging		Memo	61	0.00					/c	13/4	9 (23)
Packaging	,	4							•	, ,	

QC

QC21- Final Inspection - Work Order Release

0.00

Memo

0.00

Quality Control

13/4/co 70 Mt (349

						•						DQA:	Dat	te:	
NCR:	Yes	/ No				WORK ORDER NON-	COI	NFORM	MANCE / UP	DATE					···
								•				QA Closed:	Dat	te:	<u>-</u> .
Work Ord	er:		,			DISPOSITION		AGAINST DEPARTMEN				PARTMENT	PROCESS		
Part No.						<b>!</b>		Skid-tube Crosstube Small Fab Finishing		Water Jet Prod. Eng. Coor. Rec/Store/Packaging		Engineering Quality Other			
NCR	No.					Work Order Update	]		Large Fab	Composite			Supplier		
Root Cause		Date	Step	Qty	1	ption of work order update	1	Initial nief Eng		tion ription		Sign & Date	, Verification	n	QC Inspector
Doc/Data Equip/Tooling Operator Material Setup Other Process Supplier Training Unapproved		Buc	Step -	acy.										:	
ļ			<del> </del>				AUL	T CATE	GORY						
Landi	ing (	Gear Bending				<b>General</b> Bend		Grain		Γ		Ovalized			Pressure/Forced
		Centre No Cracks Crushed/ Cuffs			O/S	BOM/Route Broken/Damaged Burrs Contamination		Hardware Inspection Incomplete Instructions Incomplete/Unclear Maintenance				Over/Under Part Incorred Part Lost/Mi Part Moved	ct		Temperature/Cure Weld Wrong Stock Pulled
	Heat Treat					Countersink		Mislabe	led	,		Positioned V	Ŭ I	_	املاء
1	Inspection Strip in Tube Cut Too Short				Misread				Power Loss/	Surge		Other.			

Offset

Out of Calibration

Out of Sequence

Outside Dimensions

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Ripples in Bend

Turning Sequence

Wave/Twist in Tube

Torque Waves in Extrusion

Drill Holes

Drawing

Finish

Folio

## **Picklist Print**

July-19-12 11:30:31 AM

Parent Item Name: Gasket

Work Order ID: 87939

\*87939\*

Parent Item:

D3245-7

\*D3245-7\*

**Start Date:** 19/07/2012

**Required Date:** 02/08/2012

Page 1

**Start Qty: 20.00** 

Required Qty: 20.00

Comments:

IPP C04.11.17Made in-houseKJ/JLM

ECN 1052 07-10-31 DD verified by:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D3245		Manufactured	No		* ***	100	Each	0.1000	1	20		Mirate and the control of the control	
*D3245*									**	14 .	5.F.		Jm13-4-8

Location MAT052

77224

Loc Qty 0.1

0.1

Loc Code

										•	DQA:	Date:	
NCR:	Yes	/ No				WORK ORDER NON-O	COI	NFORM	MANCE / UPI	DATE			
											QA Closed:	Date:	
Work Ord	er.					DISPOSITION				AGAINST DE	PARTMENT,	/PROCESS	
WOIK OIG	C1.			<del></del>		Rework		Skid-tube	Crosstube	Water Jet		Engineering	
Part I	No.					Scrap	•	Machining	Small Fab	Pro	d. Eng. Coor.	Quality	
				·	<del></del>	`    [		1	noforming	Finishing	1	e/Packaging	Other
NCR No.				<u> </u>	Work Order Update	]		Large Fab	Composite		Supplier		
Root					Descri	ption of work order update		Initial	Act	ion	Sign &		
Cause		Date	Step	Qty	C	or Non-conformance	Ch	ief Eng	Descr	ription	Date	Verification	QC Inspector
Doc/Data													
Equip/Tooling	Ш					·							
Operator									-				
Material	L					•							
Setup											·		
Other											ļ		
Process	$ldsymbol{ldsymbol{ldsymbol{ldsymbol{ld}}}$												
Supplier					•								
Training													
Unapproved													
						F.	AUL	T CATE	GORY	· · · · · · · · · · · · · · · · · · ·			
Landi	ng (	ear				General		-			•		_
		Bending				Bend	L	Grain			Ovalized		Pressure/Forced
	Centre Not Concentric to O/S BOM/Route				BOM/Route	L	Hardwa	re		Over/Under	tolerance	Temperature/Cure	
	Cracks Broken/Damaged					Inspecti	on Incomplete		Part Incorre	ct	Weld		
	Crushed/Crimped. Burrs				Burrs		Instruct	ions Incomplete/l	Jnclear	Part Lost/Mi	ssing	Wrong Stock Pulled	
	Cuffs - Contar				Contamination		Mainte	nance		Part Moved		_	
		Heat Trea	t			Countersink		Mislabe	led		Positioned V	Vrong	_
	Inspection Strip in Tube Cut Too Short			Г	Misread			Power Loss/	Surge	Other			

Offset

Out of Calibration

Out of Sequence

Outside Dimensions

Turning Sequence

Wave/Twist in Tube

Ripples in Bend

Torque Waves in Extrusion

Drill Holes

Drawing

Finish

Folio

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DART AEROSPACE LTD	Work Order:	87939
Description: Gasket	Part Number:	D3245-7
Inspection Dwg: D3245 Rev: C		Page 1 of 1

## FIRST ARTICLE INSPECTION CHECKLIST

	LIKOI	AKTICLE IN	SPECII	JN CHE	CKLIS I	
Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
Ø0.325	+0.006/-0.001	0.325	-		V	Ikmoi
0.80	+/-0.030	0.791	_		V	
0.34	+/-0.030	0,340			V	
0.400	+/-0.010	0.400	_		V	
7.80	+/-0.030	7,80°	_		V	
2.150	+/-0.010	2.150"	-		V	
3.500	+/-0.010	3.5000	-	·	V	
0 <del>.035</del> 0"	+/-0.010	0.050"	-		V	
		į.				
						,
· · · · · · · · · · · · · · · · · · ·						
		-	OA i			
	<u></u>		<u></u>			<u> </u>
Measured by:	Jm	Audited by:	**	F	Preliminary Ap	proval:

Measured by:	Jm	Audited by:	24	Preliminary Approval:	
Date:	13-4-8	Date:	1348	Date:	

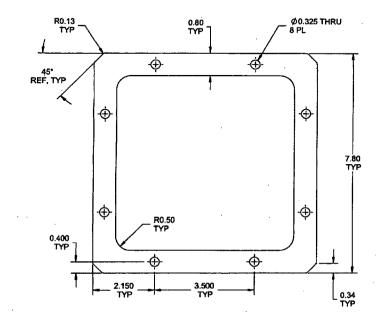
Rev	Date	Change	Revised by	Approved
Α	09.05.04	New Issue	KJ/DD IA	
B	12.05.14	Dwg Rev updated	KJ SA	(111
 			·	

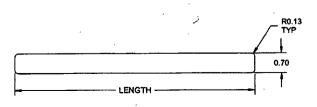
					÷				DQA:	Date:	
NCR: Yes	/ No	·			WORK ORDER NON-C	ONFOR	MANCE / UP		QA Closed:	Date:	
Work Order					DISPOSITION	DISPOSITION AGAINST DEPARTMENT/PROCESS					
Part No.  NCR No.					Rework Scrap Use-as-is Work Order Update	Scrap Machining Small Fab Use-as-is Thermoforming Finishing				Water Jet d. Eng. Coor. e/Packaging Supplier	Engineering Quality Other
Root				Descri	ption of work order update	Initial	Ac	ction	Sign &		
Cause	Date	Step	Qty	C	or Non-conformance	Chief Eng	Desc	cription	Date	Verification	QC Inspector
Doc/Data Equip/Tooling Operator Material Setup Other Process Supplier Training											

FAULT CATEGORY										
Landing Gear		General								
	Bending	Bend		Grain		Ovalized.	Pressu	re/Forced		
	Centre Not Concentric to O/S	BOM/Route		Hardware		Over/Under tolerance	Tempe	erature/Cure		
	Cracks	Broken/Damaged		Inspection Incomplete		Part Incorrect	Weld			
	Crushed/Crimped.	Burrs		Instructions Incomplete/Unclear		Part Lost/Missing	Wrong	Stock Pulled		
	Cuffs	Contamination		Maintenance		Part Moved				
	Heat Treat	Countersink		Mislabeled		Positioned Wrong				
	Inspection Strip in Tube	Cut Too Short		Misread		Power Loss/Surge	Other			
	Ripples in Bend	Drill Holes		Offset	-					
	Torque Waves in Extrusion .	Drawing		Out of Calibration						
	Turning Sequence	Finish		Out of Sequence						
	Wave/Twist in Tube	Folio		Outside Dimensions				·		

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Unapproved





## D3245-X GASKET

P/N	LENGTH
D3245-9	8.35
D3245-11	9.01
D3245-13	9.50

**D3245-7 GASKET** 

D

å

		•				
DESIGN	<b>1</b>	DART AEROSPACE LTD				
DRAWN		HAWKESBURY, ONTARIO, CANADA				
CHECKED	141	DRAWING NO.	REV. D			
MFG. APPR.	M	D3245	SHEET 7 OF 7			
APPROVED	MIN	TITLE	SCALE			
DE APPR.		ACCESS PANEL ASSY	NTS			
DATE 12.1	0.16	COPYRIGHT © 2014 BY DART AEROSPACE LTD THE COOLING IS PRIMATE AND CONTROL OF BUILDING THE PRIMATE WAY OF THE W				

NOTES:
1) MATERIAL: THERMO-CHEM P/N G-89, 0.080 THICK
POSSIBLE SUPPLIER: A.R. THOMSON GROUP
2) FINISH: NONE
3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
4) UNITS: INCHES UNLESS OTHERWISE NOTED
5) BREAK SHARP EDGES: N/A
6) IDENTIFICATION: N/A
7) WEIGHT: D3245-7 = 0.04 lbs; D3245-9/-11/-13 = LESS THAN 0.01 lbs